

Date: Friday, 09/05/2008 1:45:38 PM
 User: Julie Lecocq

Process Sheet

| | | | | | | |
|-----------------------|--|----------------------|------------------|--------------------------|------|-------------|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : FLOOR PROTCTOR AFT .LH | | |
| Job Number | : 39161 | | Part Number | : D32813 | | |
| Estimate Number | : 11228 | | Drawing Number | : D3281 REV. D | | |
| P.O. Number | : | | Project Number | : N/A | | |
| This Issue | : 09/05/2008 | S.O. No. : | Drawing Revision | : D | | |
| Prsht Rev. | : NC | | Material | : | | |
| First Issue | : / / | Type : THERMOFORMING | Due Date | : 16/05/2008 | Qty: | 10 Um: Each |
| Previous Run | : 38020 | | | | | |
| Written By | : | | | | | |
| Checked & Approved By | : JUD 08.5.09 | | | | | |
| Comment | : Est Rev:A 04.07.01 New issue KJ/JLM Est Rev B 07.08.07 Thermoform in house DL Est Rev. C 08.02.06 To reflect updated Dwg. DL Est Rev. D 08.04.15 Material Change DL | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|--|-----------------------|--|
| 1.0 | MLEXS093F600602 | GE PLASTICS LEXAN SHEET |
| | | |
| Comment: Qty.: 4.3330 sf(s)/Unit Total : 43.3300 sf(s) GE PLASTICS LEXAN SHEET | | |
| | Material Batch Number | M 106751 |
| 2.0 | HAND FINISH TH | HAND FINISHING THERMOFORMING |
| | | |
| Comment: HAND FINISHING THERMOFORMING | | |
| 3.0 | THERMOFORMING | THERMOFORMING MACHINE |
| | | |
| Comment: THERMOFORMING MACHINE | | |
| Thermoform as per Dwg. D32811and Folio FTA 009 | | |
| Dwg. Rev. <u>B</u> Folio Rev. <u>B</u> | | |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| | | |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:45:38 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTCTOR AFT LH

Job Number: 39161

Part Number: D32813

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

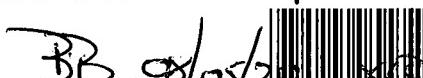
1) Trim to Finished Dimensions

BB

08/05/20 X10

6.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

BB

08/05/20 X10

2) Check dimensions to ensure conformity to drawing tolerances

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/05/20 400

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

8/5/21

10x
SD

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/20 X10

Job Completion:



MF 08-05-01

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

| | | |
|--------------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 39(6) |
| Description: Floor Protector, Aft LH | Part Number: | D3281-3 |
| Inspection Dwg: D3281 Rev: D | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than 0.1875" | / | | | |
| Shape Definition | / | | | |
| Texture Retention | / | | | |
| Material imperfections such as bumps, cracks, voids, scratching | / | | | |

Measured by: RB

Date: 08/05/20

TRIMMING SECTION

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 17.8 | +/-0.100 | 17.75 | / | | | |
| 17.1 | +/-0.100 | 17.15 | / | | | |
| 14.3 | +/-0.100 | 14.3 | / | | | |
| 0.95 | +/-0.030 | .977 | / | | | |
| 0.25 | +/-0.030 | .227 | / | | | |
| 3.1 | +/-0.100 | 3 | / | | | |
| 0.050 | Min | .064 | / | | | |
| 0.070 | +/-0.010 | .078 | / | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

Measured by: RB

Date: 08/05/20

Audited by:

Date: 08/05/20

Prototype Approval: N/A

Date: N/A

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|----------------|----------|
| A | 08.02.28 | New Issue | KJ/DL | |
| B | 08.04.16 | Dimensions updated per Dwg Rev D | KJ/DL <u> </u> | <u> </u> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

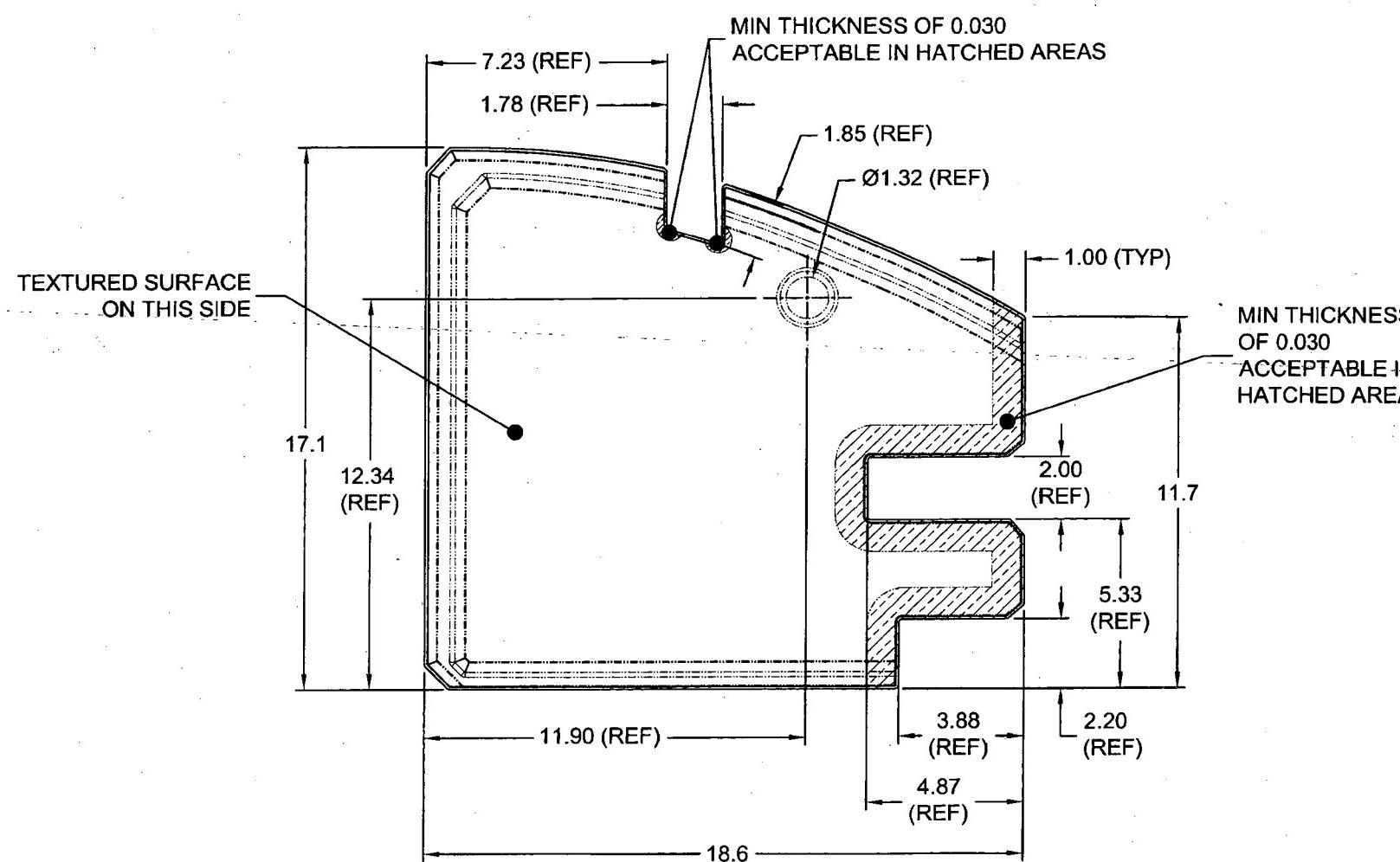
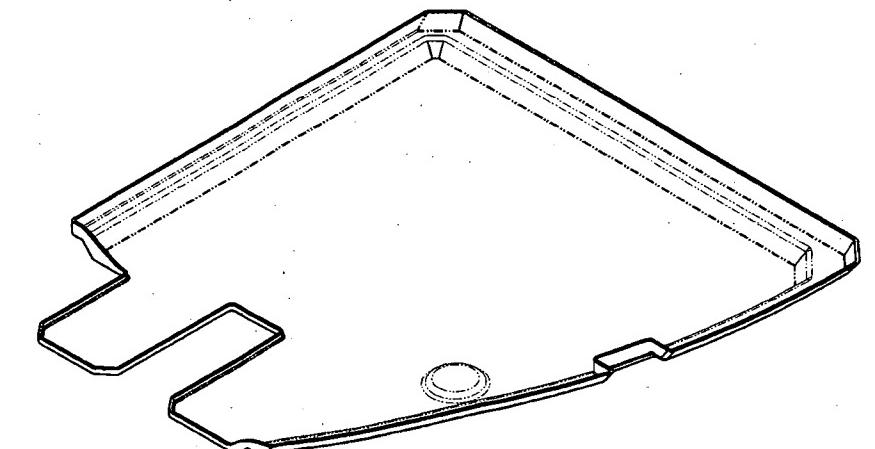
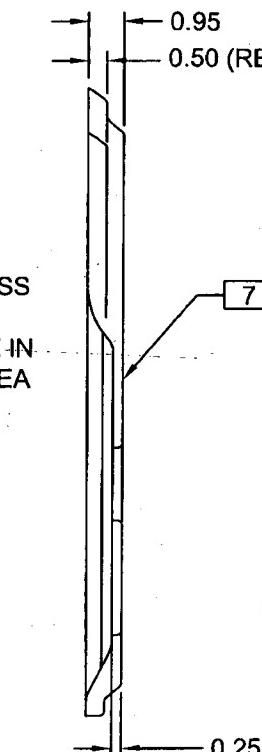
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

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**D3281-1 FLOOR PROTECTOR**

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WITHOUT NOTICE
WORK ORDER
NO. 39161

RELEASED
05.04.11 WD

D3281-1 NOTES:

- 1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.95 lb



| | | | |
|--|--|--|----------|
| D | THICKNESS 0.093 WAS 0.125, MIN THICKNESS 0.070 WAS 0.080, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-4 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A8-1, A8-2, A8-3, A8-4) | PH | 08.03.28 |
| C | UPDATE DIMS TO MATCH PARTS: COLOUR 701 WAS 700; GENERAL UPDATE | LE | 07.10.09 |
| B | NOW LEXAN; DIMS AS MANUFACTURED | CP | 05.11.25 |
| A | NEW ISSUE | CP | 04.05.03 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <i>DP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | <i>Pd</i> | | |
| CHECKED | <i>13</i> | | |
| MFG. APPR. | <i>Dh</i> | | |
| APPROVED | <i>MP</i> | | |
| DE APPR. | <i>CH</i> | | |
| DATE | 08.03.28 | SCALE | NTS |
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A

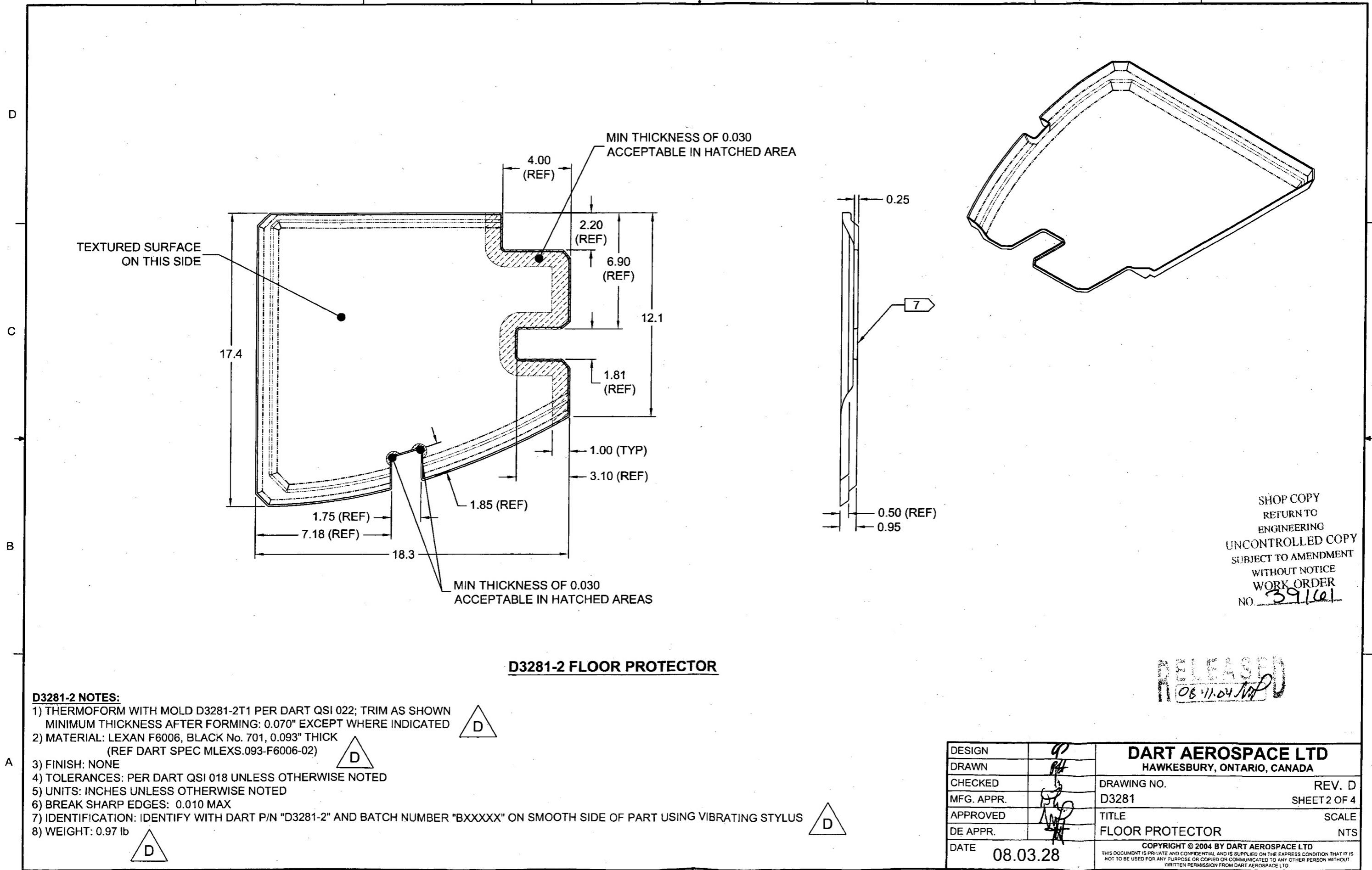
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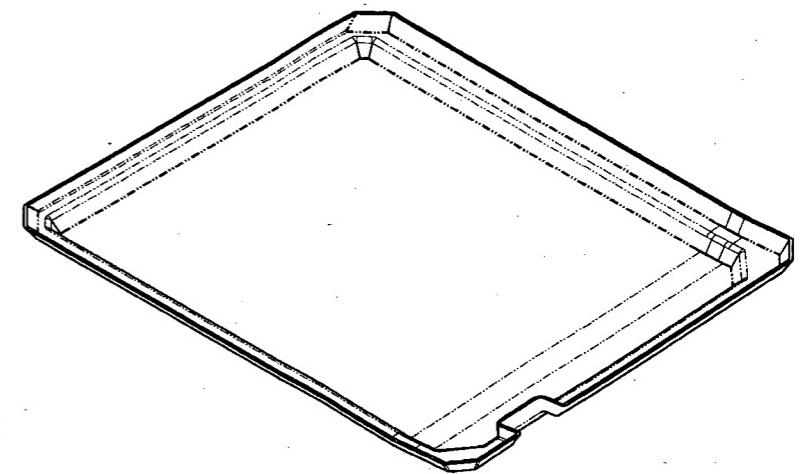
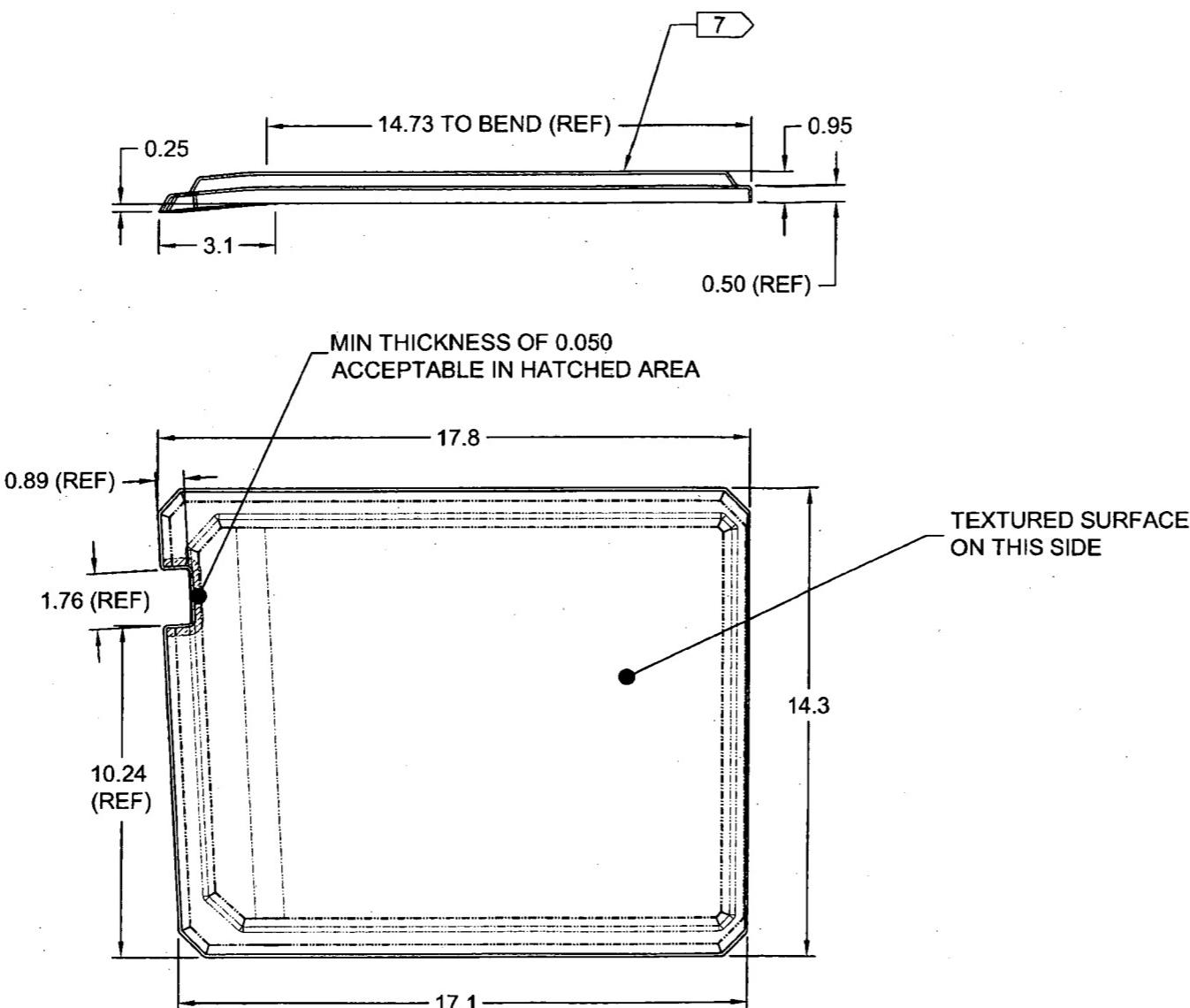


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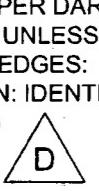
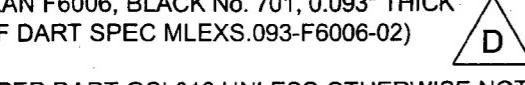
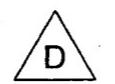


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D3281-3 FLOOR PROTECTOR

D3281-3 NOTES:

- 1) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb



| | | |
|------------|-----------|--|
| DESIGN | <u>Q</u> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| DRAWN | <u>R4</u> | |
| CHECKED | <u>JJ</u> | DRAWING NO. |
| MFG. APPR. | <u>WJ</u> | REV. D D3281 SHEET 3 OF 4 |
| APPROVED | <u>WJ</u> | TITLE FLOOR PROTECTOR |
| DE APPR. | <u>WJ</u> | SCALE NTS |
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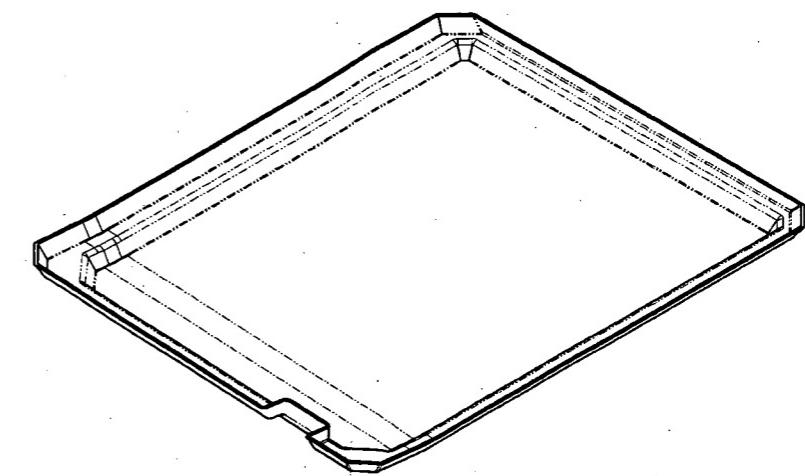
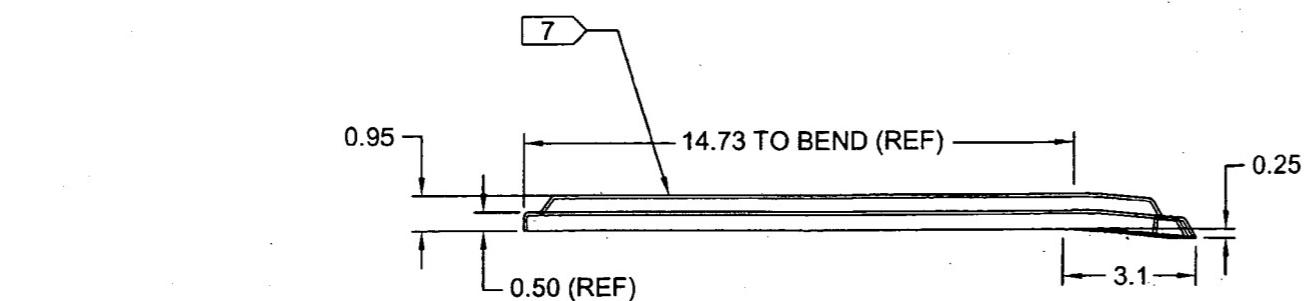
B

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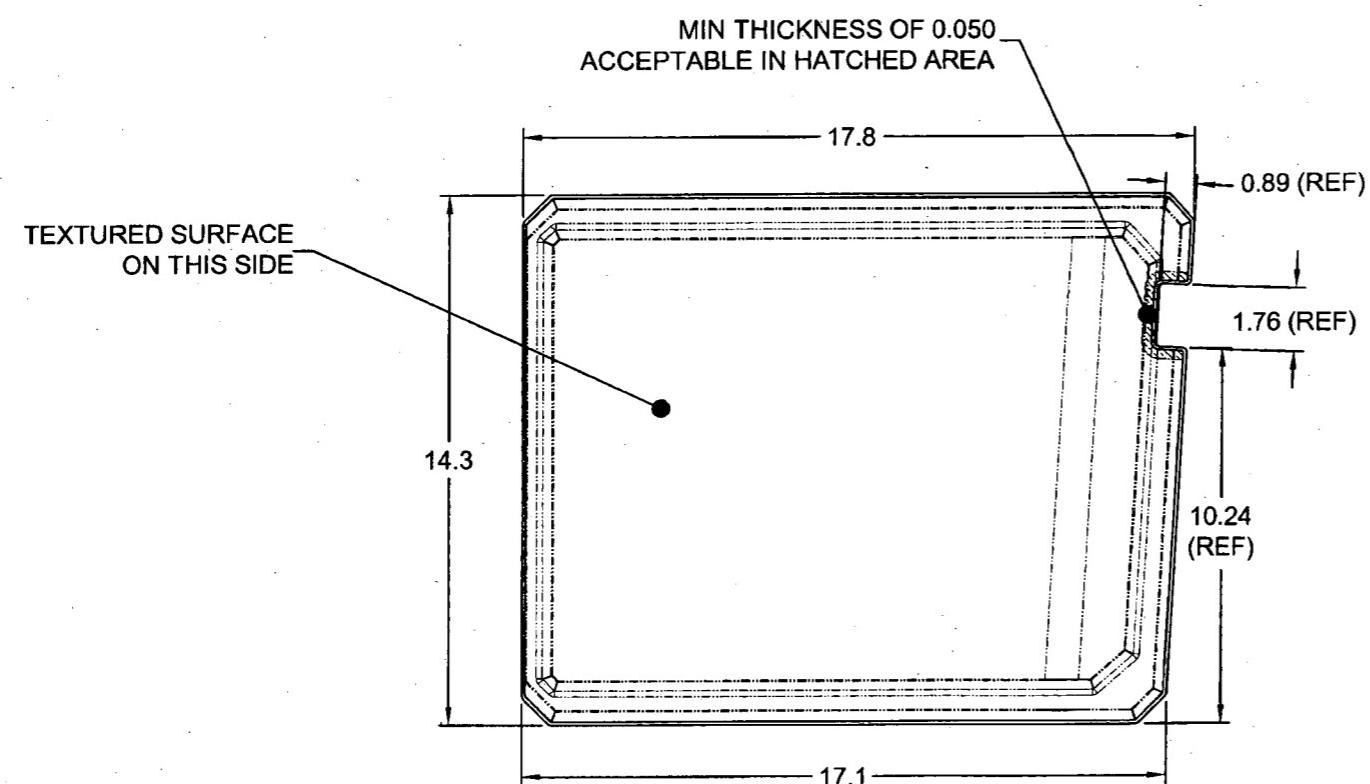
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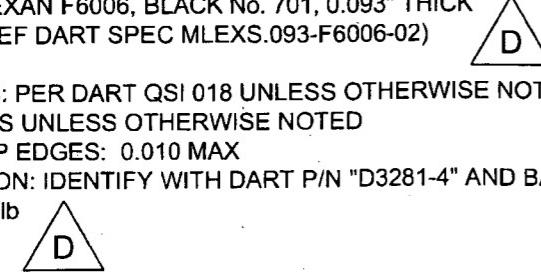


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NO. 39161

D3281-4 FLOOR PROTECTOR

D3281-4 NOTES:

- 1) THERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-4" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb



| | | |
|------------|----------|---|
| DESIGN | 9P | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| DRAWN | 44 | |
| CHECKED | | DRAWING NO. |
| MFG. APPR. | | REV. D D3281 |
| APPROVED | | SHEET 4 OF 4 |
| DE APPR. | | TITLE FLOOR PROTECTOR |
| DATE | 08.03.28 | SCALE NTS |

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